



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBBP1425-103-03
Job Sheet 175856



Part No: RBBP1425-103-03

Job Qty: 8 ea

Part Name: Keeper



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/11/18

Job Tracking No:

Due Date: 4/24/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG RBBP1425-101 Rev D IPP Rev A 18.03.13 New Issue DP Verify DD/DWG RBBP1425-101 Rev D IPP Rev B 18.04.04 DWG update DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		4/23/18	0.00	0.00	Start Up Machining-3		OK 18/04/22
100	Waterjet	6 pcs		4/23/18	0.00	0.60	Waterjet 2 OMAX		OK 18/04/22
110	Mori Seiki	6 pcs		4/23/18	0.00	3.00	MORI SL2500Y		OK
120	QC	6 pcs		4/23/18	0.00	0.00	QC2 Machining-4		OK
130	Mori Seiki	6 pcs		4/24/18	0.00	1.50	MORI NV5000-1		OK
140	QC	6 pcs		4/24/18	0.00	0.00	QC2 Machining-4		OK 18-07-31
150	QC	6 pcs		4/24/18	0.00	0.00	QC8 Machining-4		OK 18-08-02
180	Outsource	6 pcs		4/24/18	0.00	0.00	Outsource12		OK 18-08-02
200	Packaging	6 pcs		4/24/18	0.00	0.00	Packaging2		OK 18-08-02
210	QC	6 pcs		4/24/18	0.00	0.00	QC6		OK 18-08-02
215	Packaging	6 pcs		4/24/18	0.00	0.00	Packaging3		OK 18-08-02
220	QC21-SA	6 Ea		4/24/18	0.00	0.00	QC21		OK 18-08-02

Part Op 100 - 1-Cut blanks (RED BARN FOLDER)

Descriptions: 110 - 1-Machine as per folio FB 075 FOLIO REV: 9-89 2-Deburr
130 - 1-Machine as per folio FB 075 FOLIO REV: 9-89 ***Note***makes
four pieces*** 2-Deburr 3-Machine engrave as per note 6
180 - Issue P/O to Groupe Altech; PO 040674 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-S-0.500X10.000	AISI 4140 Steel Sheet/Plate	2.2200 sf (.37 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140-S-0.500X10.000	2	8	0

Part Specifications

Specifications could not be found.



Container No: S065015



Part: RBBP1425-103-03

Job No: 175856

Serial No/Batch: S065015

Revision: D

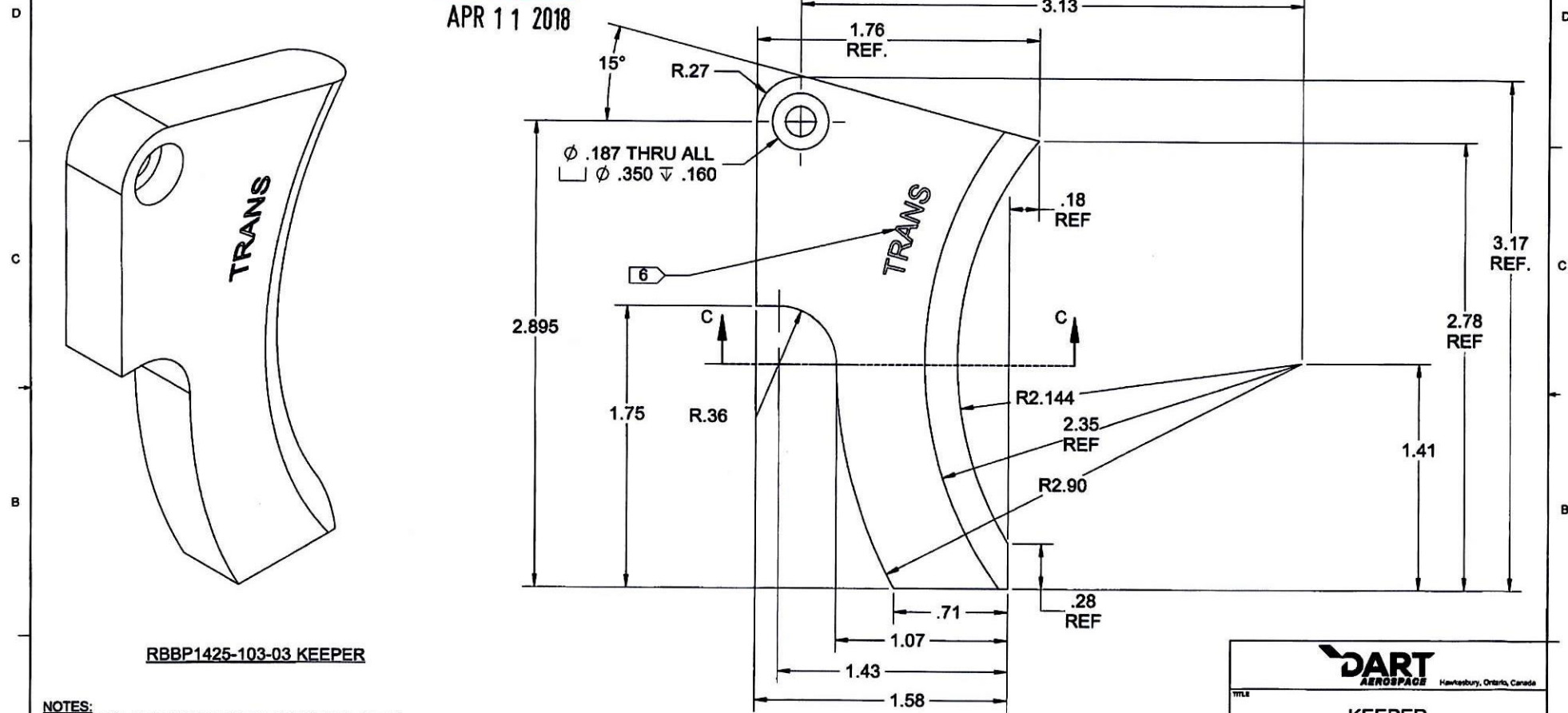
Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/25/18

APR 11 2018

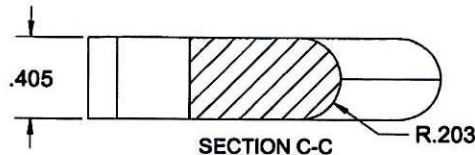
REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
C	TEMPLATE UPDATED, MATERIAL 4140/4142 CHANGED FOR 17-4 PH / H900, FINISH REMOVED, VIEWS CHANGED FOR CLARITY, NOTE 7 ADDED	17-647	18.1.23	VM	ML



RBBP1425-103-03 KEEPER

NOTES:

- NOTES:**
1) MATERIAL: 17-4 PH SS / H900 OR 4140/4142 (Rc 28-32)
2) FINISH: IF MANUFACTURED FROM 17-4PH-H900: N/A
IF MANUFACTURED FROM 4140/4142 : BLACK OXIDE PER MIL-C-13924 CLASS 1/2/4
THEN APPLY A THIN LAYER OF OIL / CPC PER
MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309
TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND
WIPE OFF EXCESS
3) HEAT TREAT: N/A
4) SPEC: N/A
5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
6) IDENTIFICATION: MACHINE ENGRAVE AS SHOWN AND FILL WITH BLACK INK, 0.010" DEPTH
7) REFER TO CAD MODEL FOR ALL NON DIMENSIONED FEATURES



SECTION C-C

		Hawthornby, Ontario, Canada	
		TITLE	
KEEPER			
PART NO.		REV	
RBBP1425-103		D	
TOOL NO. RBBP1425-103		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES RETIREMENT PER ASME Y14.36-2000 DIMENSIONS ARE IN PARENTHESES	
INITIALS AND DATE		TOLERANCES ± 1/8 FRACTIONS ± 1/8 ANGLES ± .5° SURFACE ROUGHNESS	
DESIGNED BY: VM 1/23/2018		TOLERANCES: .001 .005 .01 .03 .05 .1 .15 .2 .3 .5 1 2 3 5 10 15 20 30 40 50 60 70 80 90 100	
DRAWN BY: ML 03/20/2018		FRACTIONS: ± 1/8 ANGLES: ± .5° SURFACE ROUGHNESS	
CHECKED BY: JC 03/20/2018		FRACTIONS: ± 1/8 ANGLES: ± .5° SURFACE ROUGHNESS	
MFG REVIEW BY: DP 03/20/2018		FRACTIONS: ± 1/8 ANGLES: ± .5° SURFACE ROUGHNESS	
APPROVED BY: ML 03/28/2018		SCALE: NTS SHEET 3 OF 12	
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040677**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040677
PO Date: 8/2/18
Due Date: 8/8/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	179038	RBBP1425-103-03	Keeper -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/8/18	8 pcs	0 pcs	8 pcs	\$6.00/pcs	\$48.00
	175856			Firmed	-	8/8/18	12 pcs	0 pcs	12 pcs	\$6.00/pcs	\$72.00
Sub Total:							20	0	20		\$120.00
2	177764	C10-23	Keeper Weldment -Issue P/O to GROUPE ALTECH: P/O -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 -Bake after plating -Certificate of Conformity is required	Firmed	-	8/8/18	10 pcs	0 pcs	10 pcs	\$24.00/pcs	\$240.00
Grand Total:											\$360.00

Order Notes

Order Notes**'Procurement Quality Clauses**

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A022 Apical Processing

A024 process certifications

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/3/18 11:38 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(011515-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

011515-1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
07-Aug-2018		Aman		040677				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBBP1425-103-03, Rev.	RBBP1425-103-03 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS1	OXIDE-BLACK CH	20 ✓	20	0	0	0
2	C-10-23 ✓ Rev.	C-10-23 01-E-NIC STEEL 200 [E-NICKEL STEEL 200] QQ-N-290 CLASS2 GRADE E OR F 0.0004 TO 0.0006 AND BAKE	E-NICKEL-200 CH	10 ✓	10	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.